

Ship JAN 29

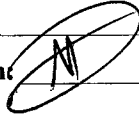
Work Order ID 140021

140021

Page 1

Thursday, December 17, 2015 9:09:45 AM

Item ID: D119-796-031 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible
 Start Date: 1/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/22/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: 12-17 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-031	A								
IIN-D119-796	E								

DEC 17 2015

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

Photocopy bluefile and create labels as per PPP D119-796-031 chg 002

110

0.00

110

HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

ASSEMBLE WITH PROSEAL BATCH: _____

2-INSTALL DECAL D2729-4

*Order changed
Close AT
Everything for back
in stock.
12-17-15*

Thursday, December 17, 2015 9:09:45 AM

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Quality Control

Work Order ID 140021***140021***

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Thursday, December 17, 2015 9:09:45 AM

Item ID: D119-796-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/22/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

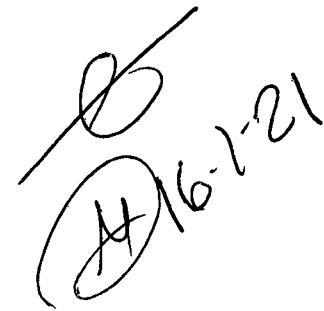
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-031 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									



Thursday, December 17, 2015 9:10:20 AM

Parent Item: D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-12 VERIFIED BY:DD
REV:B 15.08.25 AS PER ECN15-580 DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
185x90x34crate		Purchased	No				Each	0.0000		1			
										**			
Agusta Crate													
D119-646-043		Manufactured	No			110	Each	0.0000	2	2			
										**			
Repl. Skidtube with Wearpads, DART (Apical) Tri-Bag Float Compatible, Fits LH/RH													
D119-796-151		Manufactured	No			110	Each	2.0000	1	1			
										**			
FWD Crosstube Installation with Step (no hardware)													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FG			2						
				135026			1						
				135882			1						
D119-796-251		Manufactured	No			110	Each	1.0000	1	1			
										**			
AFT Crosstube Installation with Step (no hardware)													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FG			1						
				135886			1						

Picklist Print

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Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No 110 Each 525.0000 48 48

D2652

Bushing

**

DEC 17 2015

Location

Loc Qty

Loc Code

FG
31985
ST009
101032
136792
ST012a
136228

45
45
80
16
64
400
400

16
32 23

9
2

D3407-041 Manufactured No 110 Each 4.0000 2

D3407-041

Tow Ring

**

Location

Loc Qty

Loc Code

st530
134755

4
4

D3417-5 Manufactured No 110 Each 87.0000 4 4

D3417-5

Washer

**

DEC 17 2015

Location

Loc Qty

Loc Code

ST035
136618
ST038A
138368

7
7
80
80

3

1

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Shop Packet Print

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Picklist Print

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Thursday, December 17, 2015 9:10:20 AM

Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

98.0000

2

2

D3456-1

Washer

DAG

G

9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

16

135949

16

ST038A

75

136922

50

138961

25

D3672-3

Manufactured No

110

Each

1,313.000

48

48

D3672-3

Washer, Phenolic

DAG

G

9-89

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

213

132639

213

ST049

500

137234

500

ST051A

500

139583

500

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Picklist Print

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Thursday, December 17, 2015 9:10:20 AM

Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

110

Each

896.0000

48

48

D3672-7

Washer, Phenolic

********DAS**
6
9-89LocationLoc QtyLoc Code

FG

40

129987

25

133986

15

ST049

356

137756

356

ST051A

500

134786

500

48

D3883-1

Manufactured No

110

Each

10.0000

2

2

D3883-1

Saddle, Outboard LH

********DAS**
6
9-89LocationLoc QtyLoc Code

ST404

10

136811

10

2

D3883-2

Manufactured No

110

Each

7.0000

2

2

D3883-2

Saddle, Outboard RH

********DAS**
6
9-89LocationLoc QtyLoc Code

ST404

7

136812

7

2

D3884-1

Manufactured No

110

Each

10.0000

2

2

D3884-1

Saddle, Inboard LH

********DAS**
6
9-89LocationLoc QtyLoc Code

ST404

10

136813

10

2

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Picklist Print

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Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

D3884-2 Manufactured No 110 Each 7.0000 2 2

D3884-2

Saddle, Inboard RH

9-59

Location

Loc Qty

Loc Code

ST404

7

136814

7

2

AN3C45A

Purchased No

110 Each

60.0000

12

12

AN3C45A

BOLT

Location

Loc Qty

Loc Code

ST346

60

122843

20

125045

40

12

D3886-041

Manufactured No

110 Each

14.0000

4

4

D3886-041

Lug Assembly

Location

Loc Qty

Loc Code

ST528

14

135036

12

93391

2

2

2

DEC 18 2015

Picklist Print

Thursday, December 17, 2015 9:10:21 AM

Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

110

Each

208.0000

8

8

AN3C46A

Bolt

125389 VV

Location

Loc Qty

Loc Code

FG

10

122843

10

OVER002

140

M132169

70

M133332

70

ST346

58

M125389

4

M125730

8

M132522

34

M133090

12

AN3C50A

Purchased

No

110

Each

165.0000

16

16

AN3C50A

Bolt

DEC 18 2015

Location

Loc Qty

Loc Code

OVER002

80

M133606

80

ST

40

OVER002

40

ST346

45

M124027

8

M125389

8

M125606

4

M126482

4

M133432

21

Picklist Print

Thursday, December 17, 2015 9:10:21 AM

Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

221.0000

24

24

AN4C6A

Bolt

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

100

m133515

100

ST345

107

m131410

2

m132930

105

58

24

MS21043-3

Purchased

No

110

Each

834.0000

36

36

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

117

m130673

15

m131677

102

ST302

478

m133031

78 57

m133577

400

ST304

111

m131340

111

ST308

37

m132551

37

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Picklist Print

Thursday, December 17, 2015 9:10:21 AM

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Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,415.000

26

26

MS21043-4

~~133370~~

Nut

Location

Loc Qty

Loc Code

CCK007

800

m133769

800

FG

40

104603

40

GA

31

m128798

31

ST302

544

m132803

300

m133316

244

26

MS21043-5

Purchased

No

110

Each

188.0000

8

8

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

76

116548

76

ST302

92

m132382

92

8

MS21250-05048

Purchased

No

110

Each

50.0000

8

8

MS21250-05048

133157

Bolt (use MS21250-05-048)

ST295

Location

Loc Qty

Loc Code

over006

50

m133694

50

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Picklist Print

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Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

3,166.000

48

48

NAS1149C0332R

WASHER

**

126319 x 42

DAG
6
9-29

Location

Loc Qty

Loc Code

FP001

1715

m126319

42

m132262

34

m132930

1004

m133284

635

GA

343

m133284

343

ST266

1108

m133284

1108

NAS1149C0432R

Purchased

No

110

Each

1,511.000

48

48

NAS1149C0432R

WASHER

**

DAG
6
9-29

Location

Loc Qty

Loc Code

GA

450

m125807

428

m131467

22

ST266

1061

m131467

67

m133577

494

m133790

500

NAS1149C0532R

Purchased

No

110

Each

257.0000

16

16

NAS1149C0532R

WASHER

**

DAG
6
9-29
DEC 18 2015

Location

Loc Qty

Loc Code

GA

60

116513

60

ST271

197

m133031

197

Thursday, December 17, 2015 9:10:21 AM

Shop Packet Print

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Picklist Print

Thursday, December 17, 2015 9:10:21 AM

Work Order ID: 140021

140021

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 1/4/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-28

Purchased

No

125

Each

74.0000

2

2

MS21920-28

Clamp

132090

D-3

0

9-89

Location

Loc Qty

Loc Code

FG

1

105884

1

LG051

1

M132169

1

LG057

72

M130400

50

M133090

22

2

DEC 18 2015

DS1 139730 X1

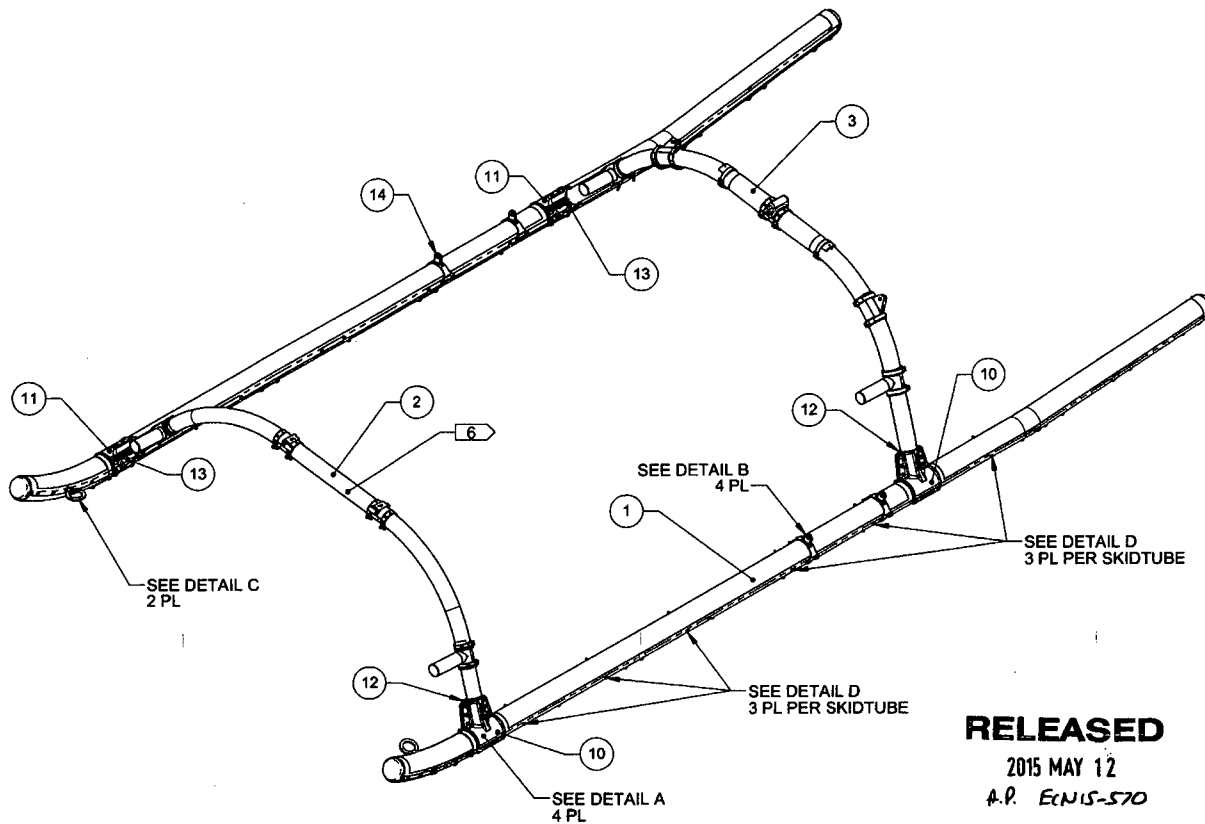
D-3

6

9-89

DEC 18 2015

ITEM	QTY -031	P/N	DESCRIPTION
	X	D119-796-031	FLOAT GEAR WITH STD WEARPADS
1	2	D119-646-043	FLOAT SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	12	AN3C45A	BOLT
16	8	AN3C46A	BOLT
17	16	AN3C50A	BOLT
18	24	AN4C6A	BOLT
19	36	MS21043-3	NUT, SELF-LOCKING
20	26	MS21043-4	NUT, SELF-LOCKING
21	8	MS21043-5	NUT, SELF-LOCKING
22	8	MS21250-05048	BOLT
23	48	NAS1149C0332R	WASHER
24	48	NAS1149C0432R	WASHER
25	16	NAS1149C0532R	WASHER



D119-796-031 FLOAT GEAR WITH STD WEARPADS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 135.5 LBS

15-12-17
140021

RELEASED

2015 MAY 12

A.P. EENIS-570

A	NEW ISSUE	AP	15.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-031	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOAT GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MS21250-05048 BOLT
NAS1149C0532R WASHER
D3672-7 WASHER
2 PL
10

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)

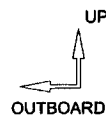
D3884-1 SADDLE (LHS)
D3884-2 SADDLE (RHS)

D3672-7 WASHER
NAS1149C0532R WASHER
MS21043-5 NUT
2 PL
10

D2652 BUSHING
D3672-7 WASHER
NAS1149C0332R WASHER
MS21043-3 NUT
4 PL
10

AN3C50A BOLT
D3672-7 WASHER
D2652 BUSHING
4 PL
10

DETAIL A
4 PL



AN4C6A BOLT
NAS1149C0432R WASHER
D3672-3 WASHER (2)
NAS1149C0432R WASHER
MS21043-4 NUT
6 PL
9

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)
REF

DETAIL A
4 PL



NOTES:

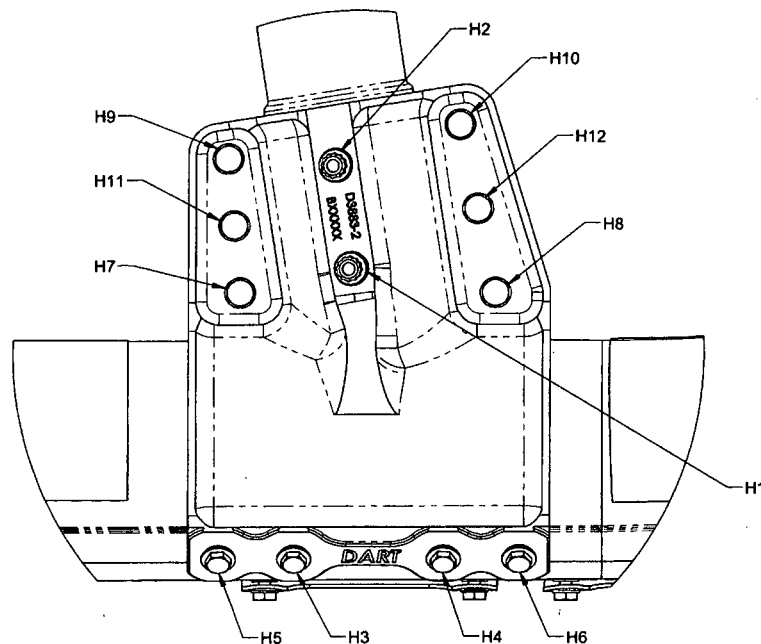
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

RELEASED

15 MAY 12

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-031	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOAT GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 N-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 N-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

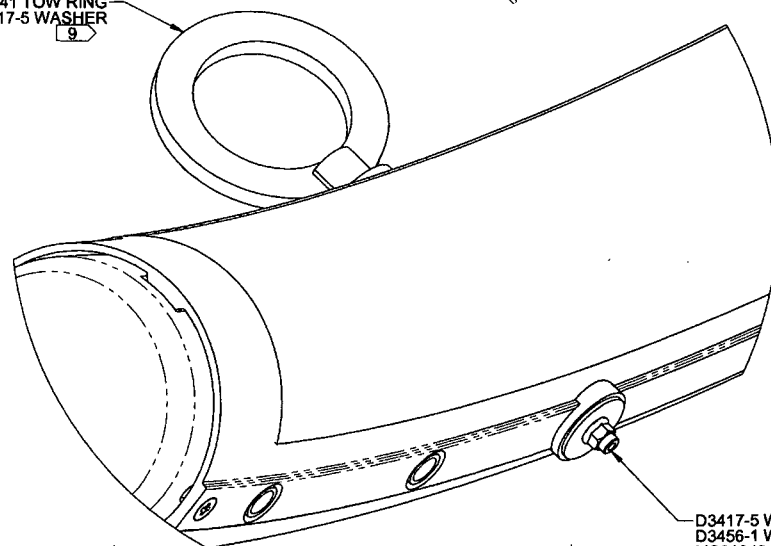
RELEASED

A.P. 2015 MAY 12

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-031	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOAT GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D3407-041 TOW RING
D3417-5 WASHER

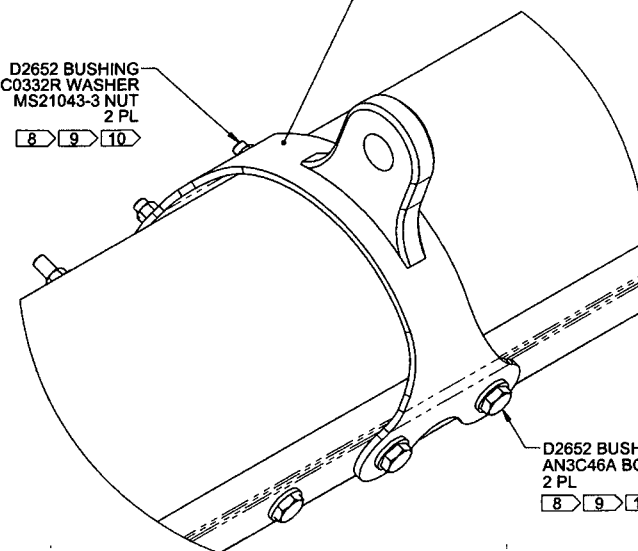


D3417-5 WASHER
D3456-1 WASHER
MS21043-4 NUT

DETAIL C
2 PL

D2652 BUSHING
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3886-041 LUG ASSEMBLY



D2652 BUSHING
AN3C46A BOLT
2 PL

DETAIL B
4 PL

RELEASED

2015 MAY 12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-031	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOAT GEAR WITH STD WEARPADS	NTS
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D

C

B

A

AN3C45A BOLT
NAS1149C0332R WASHER

MS21043-3 NUT
NAS1149C0332R WASHER
8 9



DETAIL D
6 PL PER SKIDTUBE

RELEASED

2015 MAY 12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) LOOSELY INSTALL FASTENERS, DO NOT TORQUE
- 9) INSTALL MS21043-3 NUT ON INBOARD SIDE OF SKIDTUBE

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DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-031	SHEET 5 OF 5
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